



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G19631-3G
Job Sheet 198002



Part No: RBW6305G19631-3G

Job Qty: 1 pcs

Part Name: Main Rotor Drive Tool 1 (Box 1 Of 2)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Due Date: 8/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 17721

Note: DWG RBW6305G19631-3G Rev 3 IPP Rev A 18.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	8/23/19		0.00	1.00	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	1 pcs	8/23/19		0.00	1.00	Small Fab - 1 - B4B		MCC
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
120	QC 5	1 pcs	8/23/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		



Container No: S204103



Part: RBW6305G19631-3G

Job No: 198002

Serial No/Batch: S204103

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/08/19

DAS
40
9-89

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130 Packaging 3-1 - Stock - B4B 1 pcs	8/23/19	0.00 0.00	QC 5 - 61	
			QC 5 - 81	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
140 QC 21 - FG 1 pcs	8/23/19	0.00 0.00	QC 21 - FG - 21	
			QC 21 - FG - 70	
			QC 21 - SA - 53	

Part Op **100** - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican case APP-1650-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6305G19631-3G-23 and RBW6305G19631-3G-25 to RBW6305G19631-3G-21 foam as per DWG. 6-Glue foam to case and pack case as per DWG

110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1650-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6305G19631-3G-23 and RBW6305G19631-3G-25 to RBW6305G19631-3G-21 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1650-E	Case	1 Ea (1 ea)	100-Small Fab - 1	5060662
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 2 - B4B	5163934
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5021040
RBW6305G13231-3G	Gimball Carbon Seal Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5067425
RBW6305G13731-3G	Gimball Carbon Seal Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5065876
RBW6305G14031-3G	Gimball Carbon Seal Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5067464
RBW6305G14331-3G	Upper Module Lip Seal Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5067419
RBW6305G17131-3G	Drive Quill Seal Housing Removal Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5065471
RBW6305G17631-3G	Tool Pump 1-2-3 Drive Quill Lip Seal Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5065874
RBW6305G17931-3G	Tool Pump 1-2-3 Drive Quill Lip Seal Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5061200
RBW6305G18251-3G	Guide Pumps/Ecs Drive Quill Seal Housing Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5061479
RBW6305G19631-3G-19	Bottom Foam use in case APP-1650-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5060662
RBW6305G19631-3G-21	Top Foam use in case APP-1650-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5060662
RBW6305G19631-3G-23	Inside Placard	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5204064
RBW6305G19631-3G-25	Tool Layout Placard	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5068926

Job Allocations

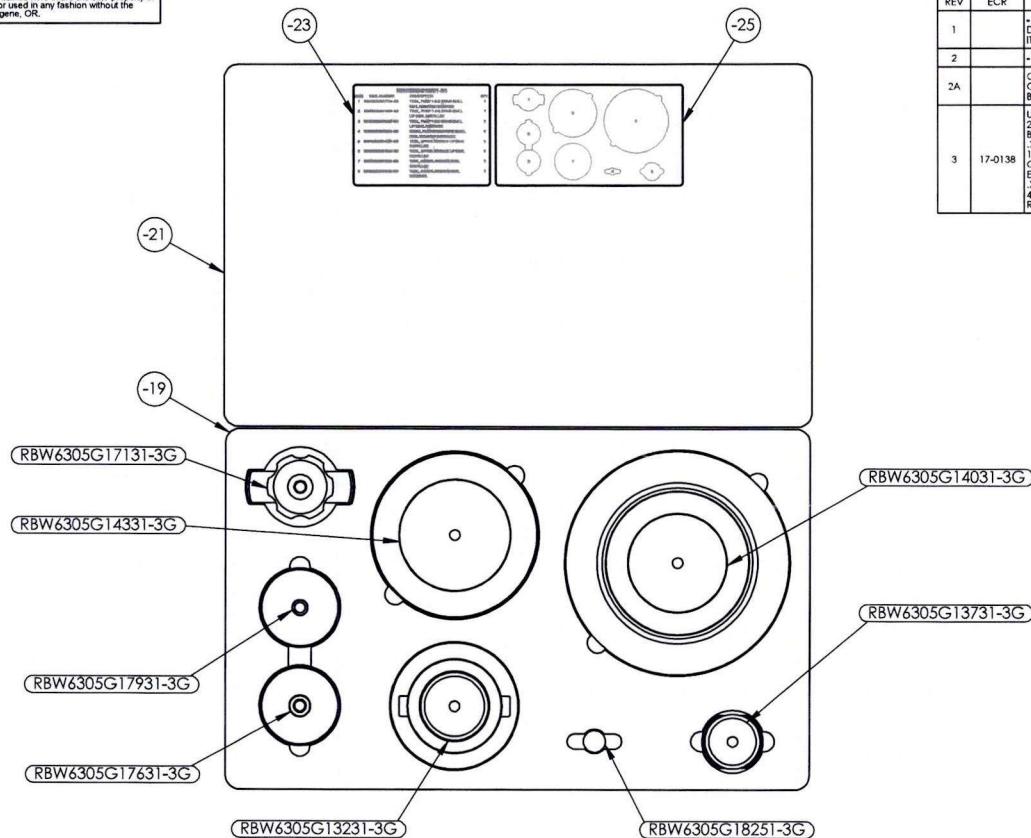
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1650-E	1	6	0
110-Small Fab - 2 - B4B	97524A032	4	161	0
	RB41011	1	274	0
	RBW6305G13231-3G	1	1	0
	RBW6305G13731-3G	1	1	0
	RBW6305G14031-3G	1	1	0
	RBW6305G14331-3G	1	1	0
	RBW6305G17131-3G	1	1	0
	RBW6305G17631-3G	1	1	0
	RBW6305G17931-3G	1	1	0
	RBW6305G18251-3G	1	1	0
	RBW6305G19631-3G-19	1	1	0
	RBW6305G19631-3G-21	1	1	0
	RBW6305G19631-3G-23	1	0	0
	RBW6305G19631-3G-25	1	2	0

Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-19 CHD FOAM DIMENSIONS, ADDED FINGER HOLES Ø3.164 CUTOFF PER R.W. CHD -21 FOAM DIMENSIONS, CHD CUTOFF TO RECESS FOR -23 & -25 PER R.W. ADDED MISSING TOOL NUMBER & ITEM NUMBERS TO -23 PER R.W.	3/29/2011	RJC	RW
2		-19 CHD FOAM CUTOFF DEPTH DIMENSIONS SO TOOLS ARE SUB-FLUSH.	2/6/2013	BIM	SE
2A		CHD TITLE WAS MAIN ROTOR DRIVE SEAL REPLACEMENT TOOL KIT IS MAIN ROTOR DRIVE TOOL KIT 1, CHD BOM DESCRIPTIONS -1 THRU -15 TO MATCH PARTS MANUAL, -23 CHD DESCRIPTIONS, WAS BUYOUT IS MANUFACTURED, CHD -25 WAS B/O IS MANUFACTURED.	10/30/2013	CFS	RJC
3	17-0138	UPDATED TO NEW DRAFTING STANDRD. -1 THRU -15 DELETED DASH NUMBERS. -19 CHD DIMS WAS 2.80 IS 3.00, WAS 50° IS 45°. ADDED DIM 2.00, DELETED DIMS 1.40, 10°. CHD B/O INFO WAS Y20 BLACK L.R. SPECIALLY IS ETHAFOAM 220 BLACK CASE SOLUTIONS, CHD TOLERANCE WAS .XXX ±.005 .XX ±.01 IS .XXX ±.010 .XX ±.03. -21 CHD DIMS WAS 29.12 IS 29.19, WAS 18.09 IS 18.10, WAS 1.80 IS 1.77, WAS 2.06 IS 2.00. -23 ADDED DIMS 4X 45°, 2X 1.00, 2X 2.75, 1.37, 8X Ø.16, SIMPLIFIED CUTOFF ON BACK OF FOAM, DELETED DIM 4X 2°. CHD B/O INFO WAS C200 FLAT BLACK L.R. SPECIALLY IS ETHAFOAM 220 BLACK CASE SOLUTIONS. -21, -23, -25 CHD TOLERANCE WAS .XXX ±.005 .XX ±.01 IS .XXX ±.010 .XX ±.03. -23, -25 ADDED USE PDF NOTE. -23 CHD DIM WAS 5.50 IS 5.00, WAS R.37 (X4) IS 4X R.13, DELETED TEXT ARIAL 3/16 LETTERS (X4), ARIAL 1/8 LETTERS. -25 CHD DIM WAS R.37 (X4) IS 4X R.13, WAS 5.50 IS 5.00, DELETED TEXT ARIAL 1/8 LETTERS.	6/13/2017	RJC	JAG

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198002 MLS
1907-22

NOTE:

1. REFERENCE AGUSTA T/N 3G6305G19631.
2. ALSO SOLD WITH KIT RBW6305G01531-3G.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	TOOL, PUMP 1-2-3 DRIVE QUILL SEAL HOUSING REMOVAL		RBW6305G17131-3G	1
				1	TOOL, PUMP 1-2-3 DRIVE QUILL LIP SEAL INSTALLER		RBW6305G17931-3G	1
				1	TOOL, PUMP 1-2-3 DRIVE QUILL LIP SEAL REMOVER		RBW6305G17631-3G	1
				1	GUIDE, PUMPS/ECRS DRIVE QUILL SEAL HOUSING INSTALLER	6061	RBW6305G18251-3G	1
				1	TOOL, UPPER MODULE LIP SEAL INSTALLER		RBW6305G14331-3G	1
				1	TOOL, UPPER MODULE LIP SEAL INSTALLER		RBW6305G14031-3G	1
				1	TOOL, GIMBAL CARBON SEAL INSTALLER		RBW6305G13231-3G	1
				1	TOOL, GIMBAL CARBON SEAL REMOVER		RBW6305G13731-3G	1
		B/O	-17	1	CASE	PLASTIC	PELICAN CASE # APP-1650-E	N/S
		B/O	-19	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	8.71 X 17.97 X 29.12 (CASE SOLUTIONS)	2
		B/O	-21	1	TOP FOAM	ETHAFOAM 220, BLACK	1.77 X 18.10 X 29.19 (CASE SOLUTIONS)	3
			-23	1	INSIDE PLACARD	PLASTIC		4
			-25	1	TOOL LAYOUT PLACARD	PLASTIC		5
		B/O		1	DART PLACARD	ALUMINIUM	RB41011	N/S

DART AEROSPACE	
TITLE MAIN ROTOR DRIVE TOOL KIT 1	
DWG NO. RBW6305G19631-3G	REV 3
MAT'L RENT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES ± 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: DD 06/14/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHIPS APPR: AA 06/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
CA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/07/2017	AW139
SCALE 1:6	DATE 2/7/2011
SHEET 1 OF 5	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			